

Monday, 3/5/2007 4:23:12 PM
 *Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PIVOT ARM
Job Number : 31021	
Estimate Number : 12771	
P.O. Number : <i>N/A</i>	Part Number : 41232 200 002 005
This Issue : 3/5/2007 S.O. No. : <i>N/A</i>	Drawing Number : 41232-200-002 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : A
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 3/30/2007
Checked & Approved By : <i>[Signature]</i> 07.03.06	Qty: <i>13</i> Um: Each
Comment : Est Rev: A New Issue 07-03-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3R1250	2024-T3 Round Bar 1.250"
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Comment: Qty.: 0.3675 f(s)/Unit Total : 4.4100 f(s)

2024-T3 Round Bar 1.250"

Batch: *M163753*

[Signature] 07-03-16 (12)

2.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE

Turn as per Dwg 41232-200-0021

[Signature] 07-03-16 (12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 07-03-16 (12)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Mill as per Dwg 41232-200-002

2-Debur

[Signature] 07-03-16 (12)

[Signature] 07-03-16 (12)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 07-03-16 (12)

6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] 07-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIVOT ARM

Job Number: 31021

Part Number: 41232 200 002 005

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING

Issue P/O: 3360

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

CL07/03/20

(13)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

CL07/03/27 (13)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB

07/04/03

10.0

MS21209C415

HeliCoil



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

HeliCoil

Batch: M103925 M104030

FF

07-04-12

11.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Install Helicoil as per Dwg 41232-200-005.

FF

07-04-12

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

07/04/12

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

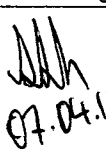
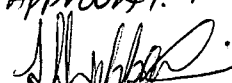
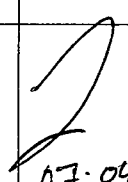

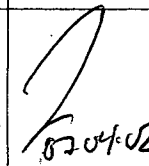
SB

07/04/12

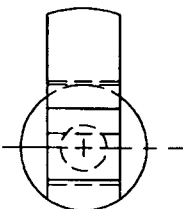
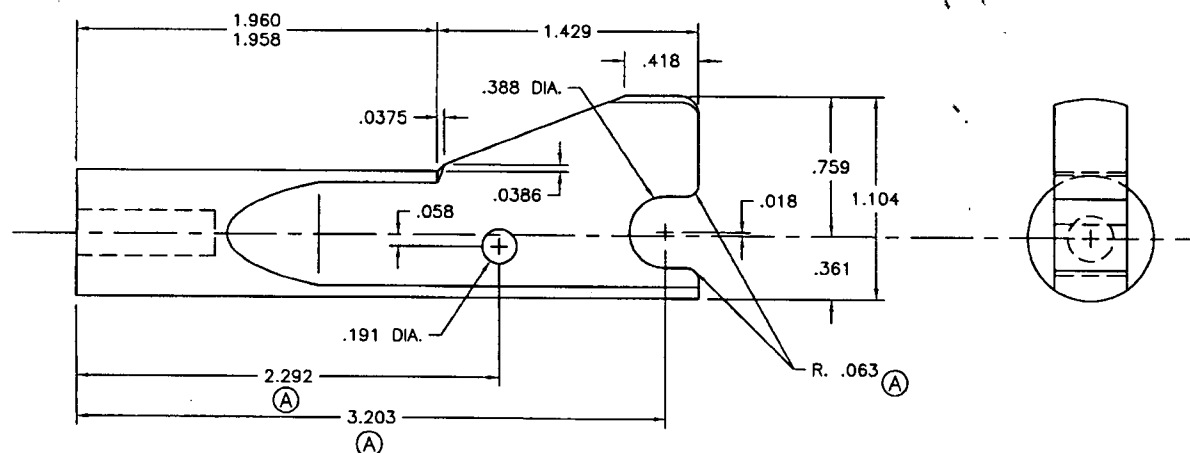
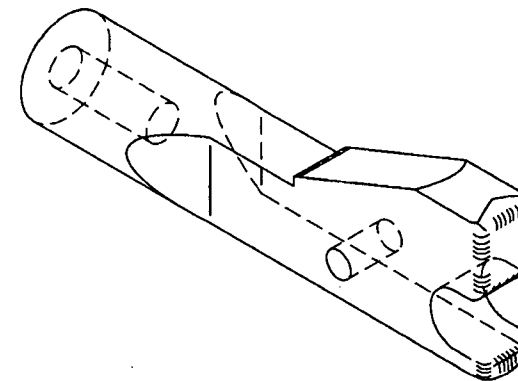
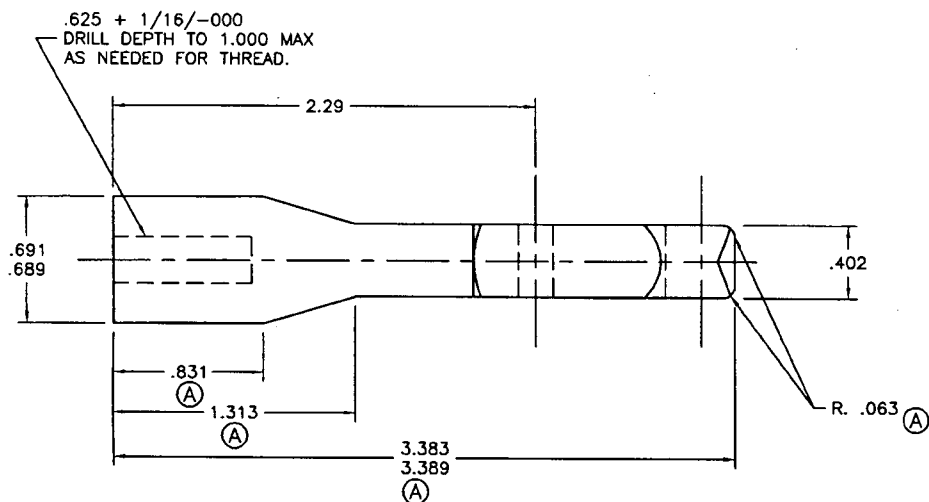
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-04-02	7.0	Parts were Anodized per Mil-A-8625F1-Type I-Class 2 per QSI 017, instead of Mil-A-8625-Type III-Class 2 per Dwg.	 07-04-13	Parts acceptable per eng. approval. As per Bill. 		 07-04-02	 as per QSI 042 07-04-13	 07-04-02

NOTE: Date & initial all entries



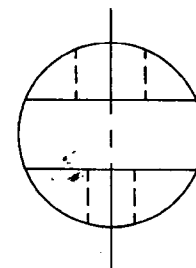
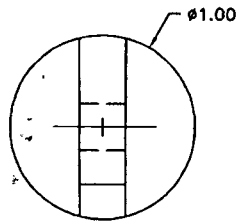
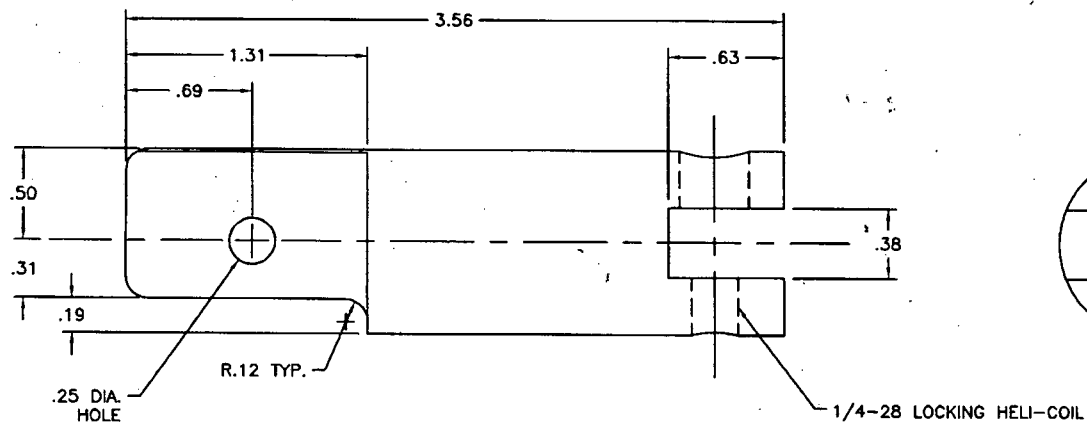
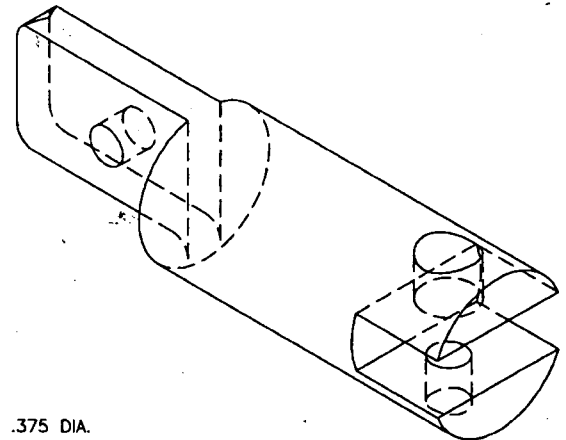
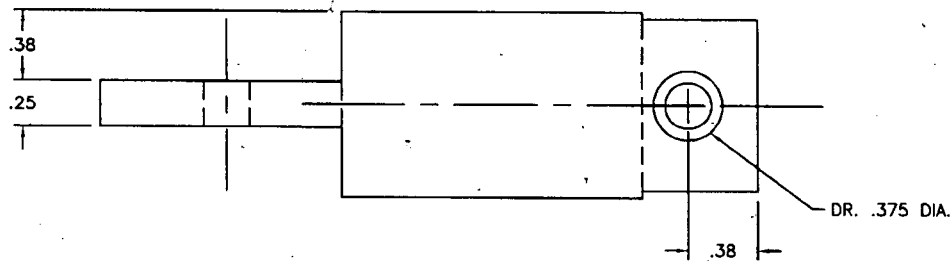
-003 LATCH

SHOP COPY
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WORK ORDER
NO. 31021

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Era Aviation, Inc.

TITLE	SIZE	DWG. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 2 OF 3	A



-005 PIVOT ARM

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Era Aviation, Inc.

TITLE
STEP ACTUATOR COMPONENTS

SIZE
C

DWG. NO.
41232-200-002
SHT 3 OF 3

REV.
A

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

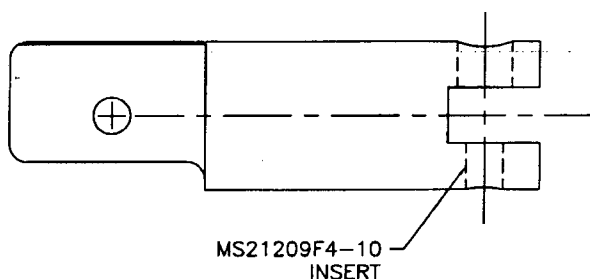
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1	MS21209F4-10	INSERT
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WAS

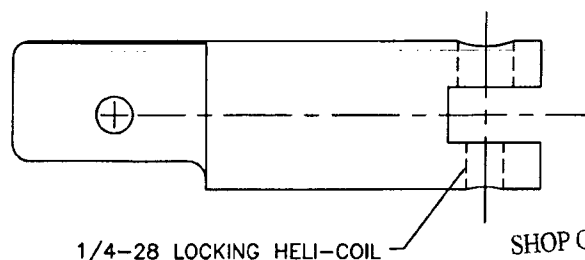
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IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM

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WITHOUT NOTICE
WORK ORDER
NO. 31021

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIVOT ARM

Job Number: 31021

Part Number: 41232 200 002 005

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(B)

Comment: FINAL INSPECTION/W/O RELEASE

P07104/13

Job Completion



L 07.11.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2

Téléphone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

**PACKING
SLIP****54032**

23-Mar-2007

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

PURCHASE ORDER/**NO. DE COMMANDE:****00003360**

1	9	9	41232-200-002-003	B31020
2	13	13	4123-200-002-005	B31021
3	13	13	41232-200-002-001	B31019

*EP 04/03/27***PICKED UP BY / RECU:** _____

En cas de perte ou de dommages dû à la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

54032

23-Mar-2007



CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE

PURCHASE ORDER/ NO. DE COMMANDE: 00003360



1	9	9	41232-200-002-003 B31020	REV: A BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2
2	13	13	4123-200-002-005 B31021	REV: A BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2
3	13	13	41232-200-002-001 B31019	REV: A BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager ☐ ☐ ☐

